

Work Order ID 84074

Wednesday, May 02, 2012 1:05:44 PM

\*84074\*

Page 1

Item ID: D3698-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Support Angle

Start Date: 5/2/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-05-2 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3698	Rev C

100

0.00

\*100\*

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3698Dwg Rev: C Prog Rev: C

6061 032

\*\*\*\*grain direction along 1.378" \*\*\*\* 2- Debur if necessary

110

0.00

\*110\*

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

120

0.00

\*120\*

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

Jm/Md  
12-5-4

Jm/Md  
12-5-4

(44)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID 84074

**\*84074\***

Page 2

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Item ID: D3698-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Support Angle

Start Date: 5/2/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Brake NC Brake NC	NC BRAKE  Memo 1-Bend 105 deg. angle as per Dwg D36982-form curve as per dwg D3698 and verify using template DT9001	0.00  0.00		SD 12106105		4	0		FF 12-06-25
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				4			W 12-06-25
150 <b>*150*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				4			W 12-6-26

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 84074

Wednesday, May 02, 2012 1:05:44 PM

**\*84074\***

Page 3

Item ID: D3698-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Support Angle  
 Start Date: 5/2/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 5/8/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>ST 241A</u>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

4/26/26 (4)

4X 80  
12-6-26

12/6/26 J

12/6-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 02, 2012 1:05:48 PM

Page 1

Work Order ID: 84074

\*84074\*

Parent Item: D3698-1

\*D3698-1\*

Parent Item Name: Support Angle

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-04-25 new issue DD verified by:EC  
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec  
IPP rev:C 08-10-07 revC as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased		No		100	sf	303.5560	0.4476	1.884632			

\*M6061T6S 032\*

\*\*

6061-T6 Sheet 0.032"

Location

Loc Qty

Loc Code

MAT021

303.556

118106

48.606

120218

33.77

120285

43.08

121099

178.1

120218

5 m / 100 ft  
12-5-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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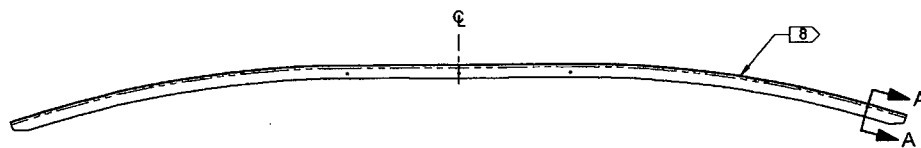
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

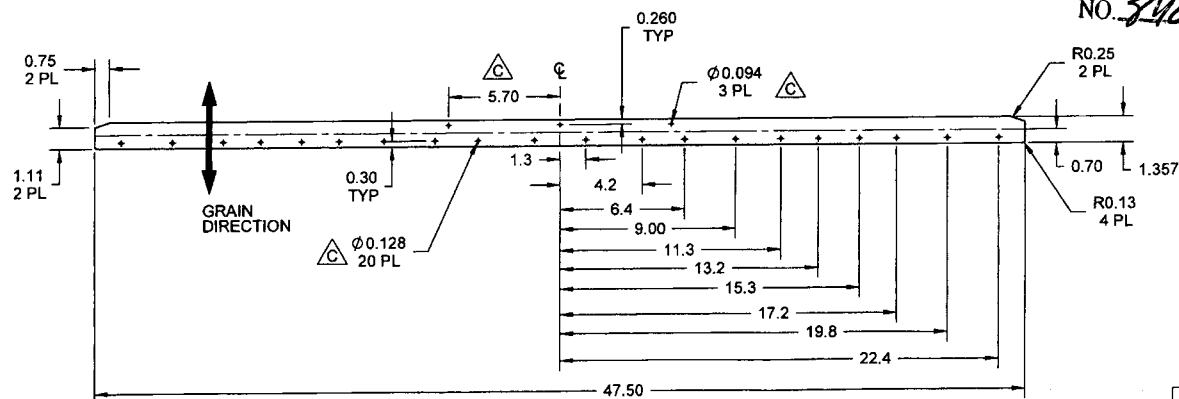
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**D3698-1 SUPPORT ANGLE**  
(MAKE FROM D3698-1F FLAT PATTERN)

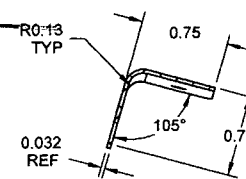


**D3698-1F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.032 THICK  
REF: DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.20 lbs
- 8) FORM AS PER TEMPLATE DT9001

*11205-2*  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *84074*



**SECTION A-A**

**RELEASED**  
*08-09-08*

C	ZONE B5 Ø0.094 HOLE QTY WAS 29 PL. ZONE B6 ADDED "Ø0.128, 20 PL". ZONE B6 5.70 DIMENSION WAS REF.	AJS	08.09.08
B	REMOVE POWDER COAT. ZONE A,B	RF	08.06.02
A	NEW ISSUE	RF	08.05.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	<b>D3698</b>	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>SUPPORT ANGLE</b>	NTS
DATE	08.09.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

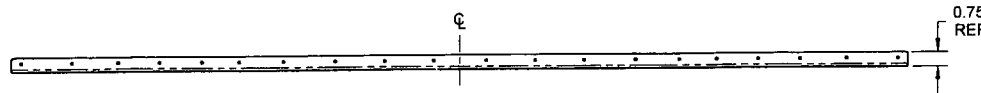
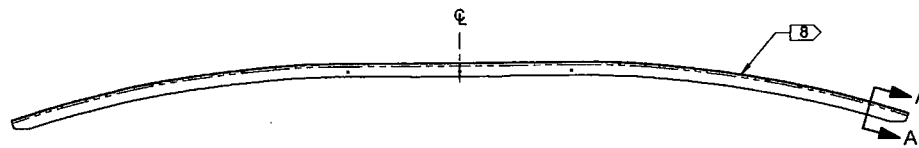
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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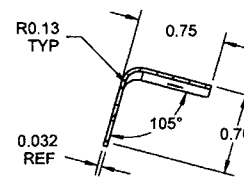
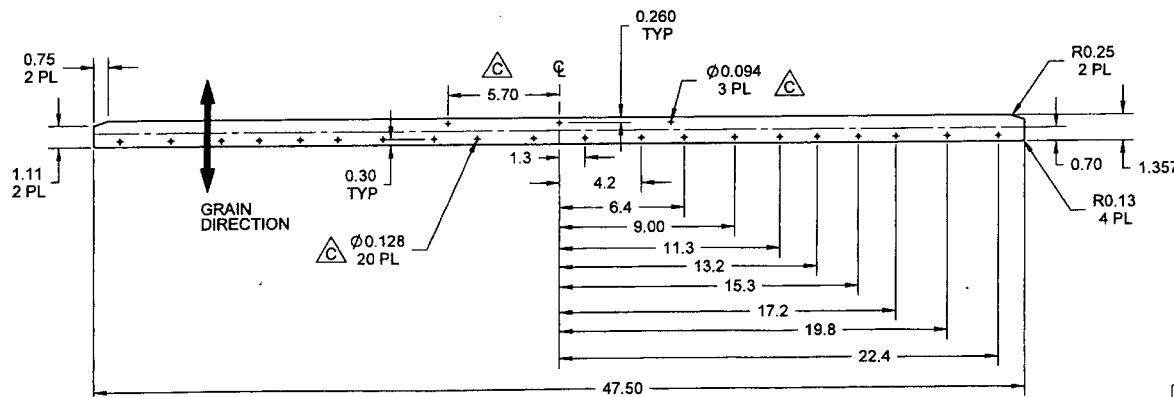
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**D3698-1 SUPPORT ANGLE**  
(MAKE FROM D3698-1F FLAT PATTERN)



**SECTION A-A**

**D3698-1F FLAT PATTERN**

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REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3698	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT ANGLE	NTS
DATE	08.09.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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